

532

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23946
<b>Description:</b> Bushing/Nut		<b>Part Number:</b>	D3176-1/-3
<b>Dwg:</b> D3176 Rev. A		<b>Qty:</b>	4
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	AP	05/08/05	4
2	MC	Turn blank per Dwg D3176 and Folio FA286 & FA287 Material: AISI 303 SS (Ref: Dart Spec: M303R1.000) thread per MIL-S-7742 Batch: <u>M17002</u>	J.G.	05/08/24	4
3	QC2	Inspect parts as they come off the CNC machine	J.G.	05/08/24	4
4	MV	Cut head as per Dwg D3176 and Folio FA286 & FA287	J.G.	05/11/23	4
5	QC2	Inspect parts as they come off the CNC machine	J.G.	05/11/23	4
6	MV	Deburr and Tumble. Cover D3176-1 thread using D3176-3 nut	J.G.	05/11/23	4
7	QC8	Second check	my	05/11/23	4
8	FP	Identify and Stock	MJ	05 11 24	4
9	AC	Cost / part	Suc	05-11-24	4
10	DC	Close W/O Inspect Level 21	QD	05/11/25	4

ADS 372  
373

240

Rev	Date	Change	Revised By	Approved
A	02.11.04	New issue	KJ RF	df

**RELEASED**  
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.08.15	2	AISI 303 NOT AVAILABLE. USE AISI 304/316 ROUND BAR FOR THIS BATCH ONLY.				UP 05.08.15 per OSI 042	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/25

NOTE: Date & initial all entries

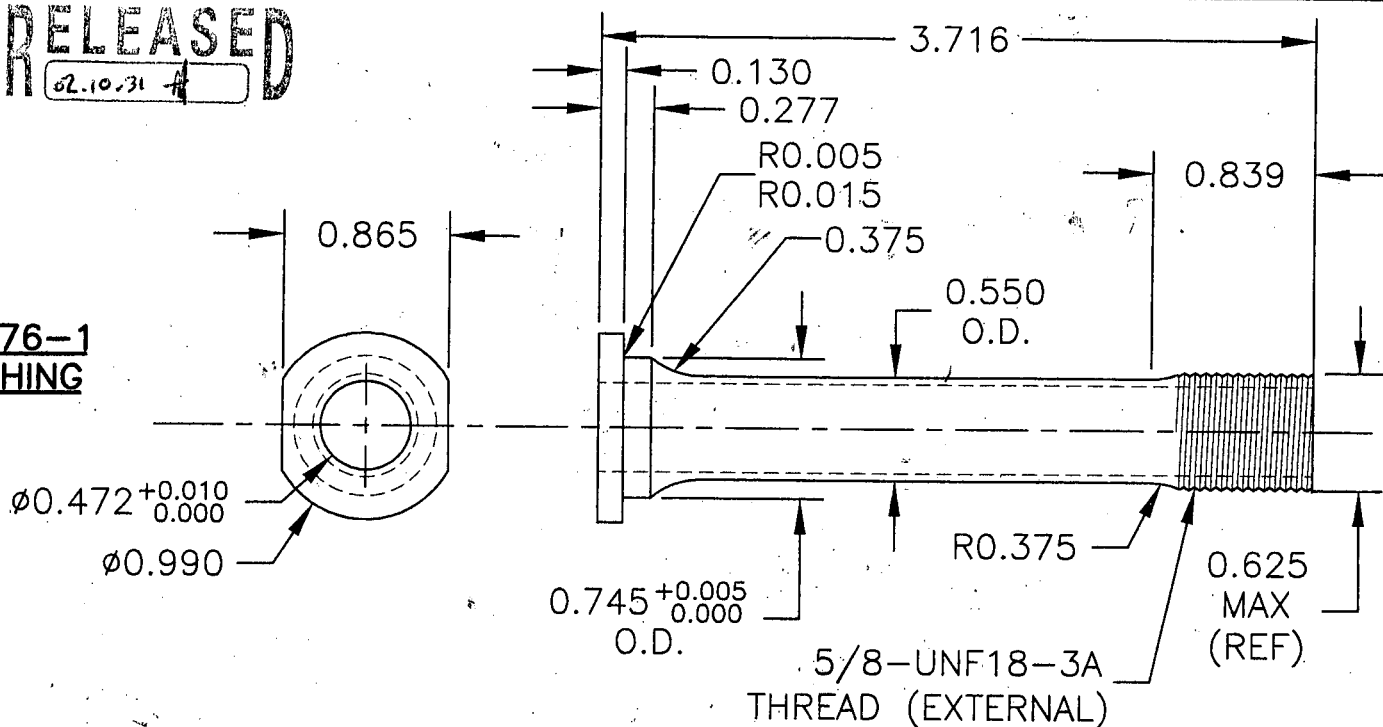
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



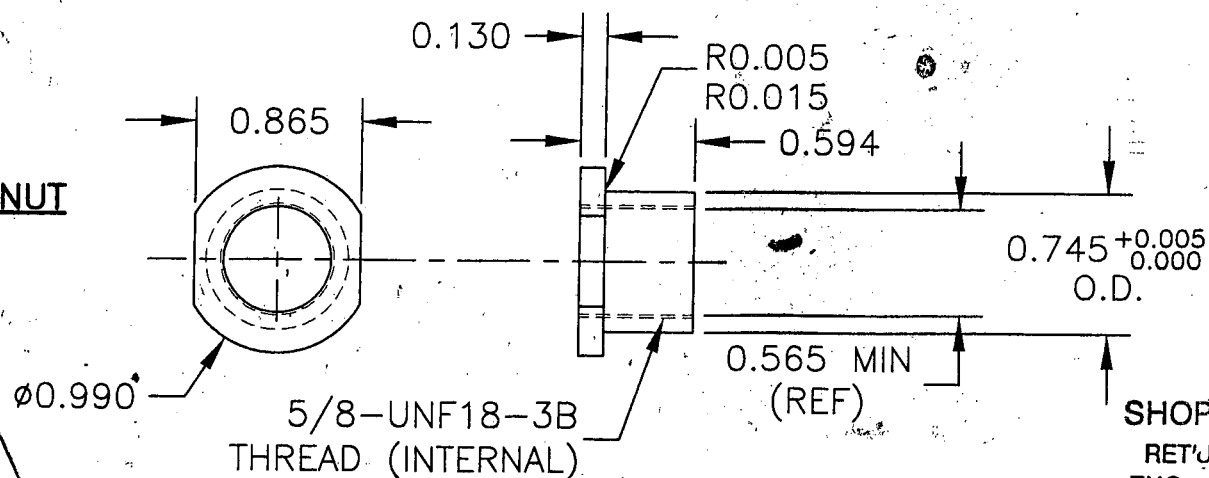
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED  
02.10.31

D3176-1  
BUSHING



D3176-3 NUT



AISI 303 S.S. (REF DART SPEC. M303R1:000)  
PER MIL-S-7742  
SHARP EDGES 0.005 TO 0.015

ALL DIMENSIONS ARE IN INCHES  
UNLESS OTHERWISE NOTED  
FOR MATING PARTS

SHOP COPY  
RETURN TO  
ENGINEERING

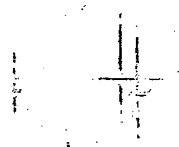
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 23946

Copyright © 2002 by DART AEROSPACE LTD

THIS DRAWING IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

105  
106  
107  
108



109  
110





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 04, 2005  
03:24 pm

Work Order No	:	0023946	Department Code:	
Project Name	:	D3176-1/-3	Burden Flags	: NNNNNNN
Project For	:	WK532	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3176-1	Invoice Number	:
Description	:	Bushing	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	08-04-05		
Est Finish Date	:	08-12-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

**Chris Provencal**

---

**From:** "David Shepherd" <davids@dartaero.com>  
**To:** "Chris Provencal" <chrisp@dartaero.com>  
**Sent:** August 15, 2005 10:51 AM  
**Subject:** Re: Mat'l Substitution

AISI 304 is acceptable as long as the parts turn OK.

David

----- Original Message -----

**From:** Chris Provencal  
**To:** David Shepherd  
**Sent:** Monday, August 15, 2005 8:05 AM  
**Subject:** Mat'l Substitution

For the D3176-1/-3 Bushing/Nut, they are out of AISI 303. They have AISI 304 available and can make it out of that instead.

Sincerely,  
**Chris Provencal**  
***DART* Aerospace Ltd.**  
Email...[chrisp@dartaero.com](mailto:chrisp@dartaero.com)  
Phone...613-632-3336  
Fax.....613-632-4443

15/08/2005